

31/08/2008 2:25:46 PM

Process Sheet

CC-DAR01 Dart Aerospace Ltd.

Drawing Name : FRONT INBOARD LEG ASSEMBLY

40870 -2

13320

Part Number : D3782041

P.O. Number :

Drawing Number : D3782 REVA

This Issue : 01/08/2008

Project Number : N/A

Prsht Rev. : NC

Drawing Revision : A

First Issue : 31/07/2008

Material :

Previous Run : 40303

Due Date : 08/08/2008

Written By :

Qty: 12 Um: Each
SP/IT/le
TOChecked & Approved By : JLD 08-8-01Comment : Est Rev:A 08-05-19 new issue DD verified by:ec
Est Rev:B 08-06-17 rev.A as per dwg DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

2.0 D37681 Front Inboard Leg



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Front Inboard Leg

batch: B40972

SB

qtrs 4 8/9/18

3.0 D37871 Foot



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Foot

batch: M40982 (x4)

FF 08/09/16

(4)

4.0 AN513A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

batch: M10867 x8

FF 08/09/16

(4)

5.0 AN960JD516 Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 36.0000 Each(s)

Washer M108672 x4batch: M108246 x4

or (NAS1149D0568J)batch:

FF 08/09/16

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 2:25:46 PM
User: Julie Lecocq

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: FRONT INBOARD LEG ASSEMBLY

Job Number: 40870

Part Number: D3782041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut 7108161 x 4

batch: M108471

FF 08/09/16

(4)

7.0 AN45 13A

EYE BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

eye Bolt

batch: M109013

SN 08/09/18

(4)

8.0 D3762041

Front Leg Fitting Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Front Leg Fitting

B40945

B40945

08/09/18

X4

9.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-assemble as per dwg D3782

****install AN45-13A eye bolt as shown for D412-769-041****

****install AN45-13A eye bolt in reverse for D412-769-042****

FF 08/09/18

4

10.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: OPA

MF 08-09-18

12.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



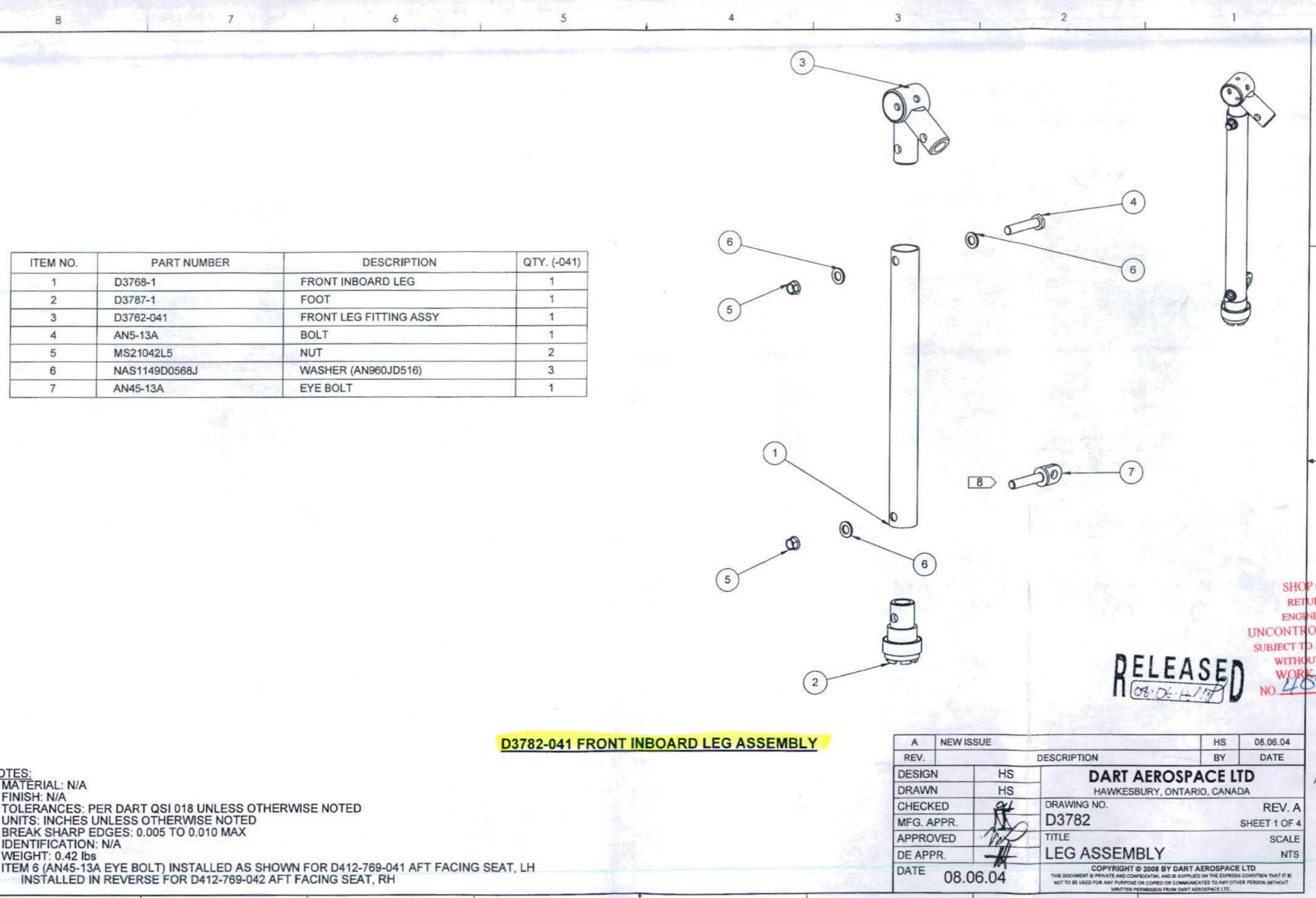
MF 08-09-18

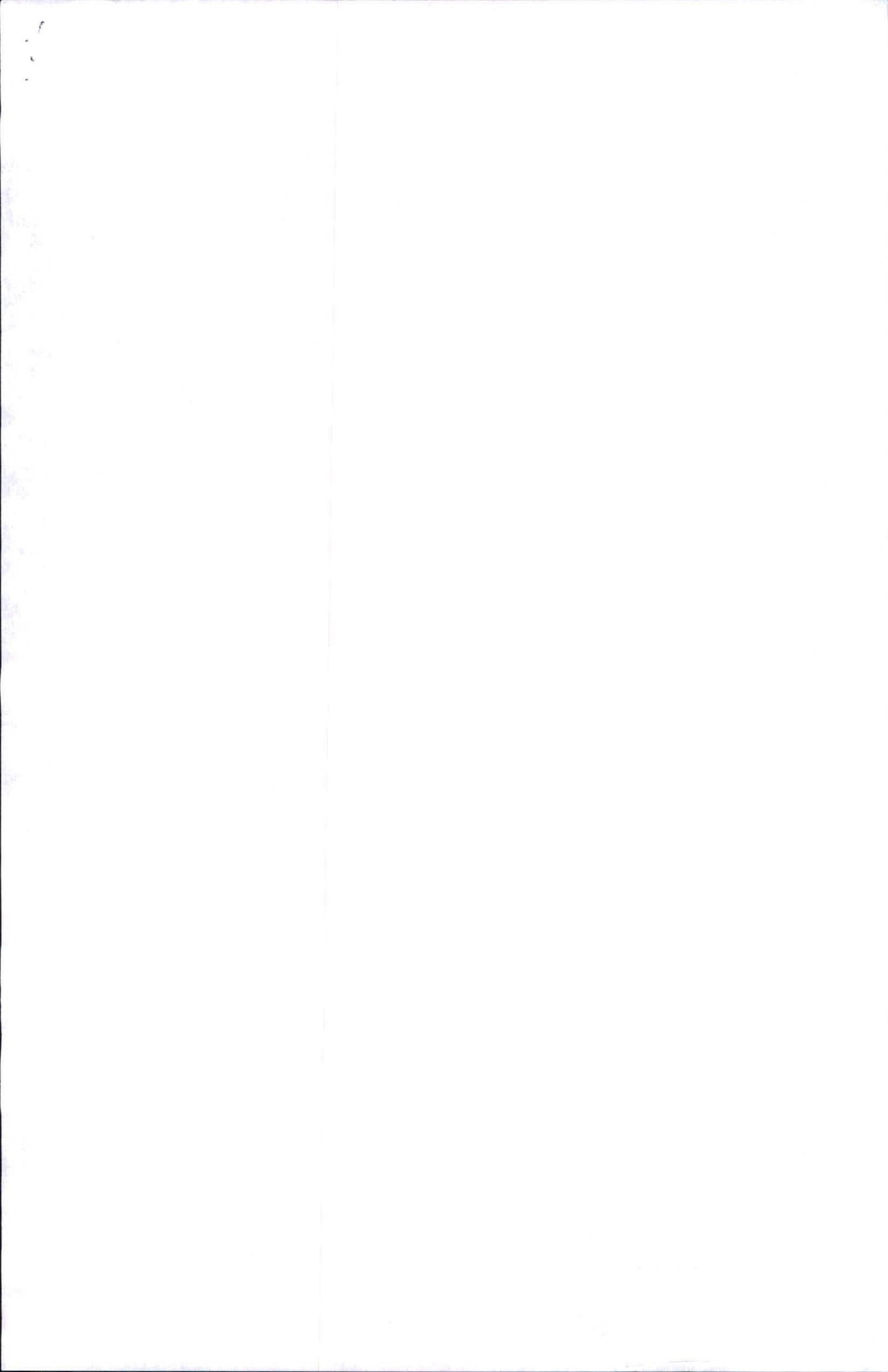
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





8 7 6 5 4 3 2 1

D

D

C

C

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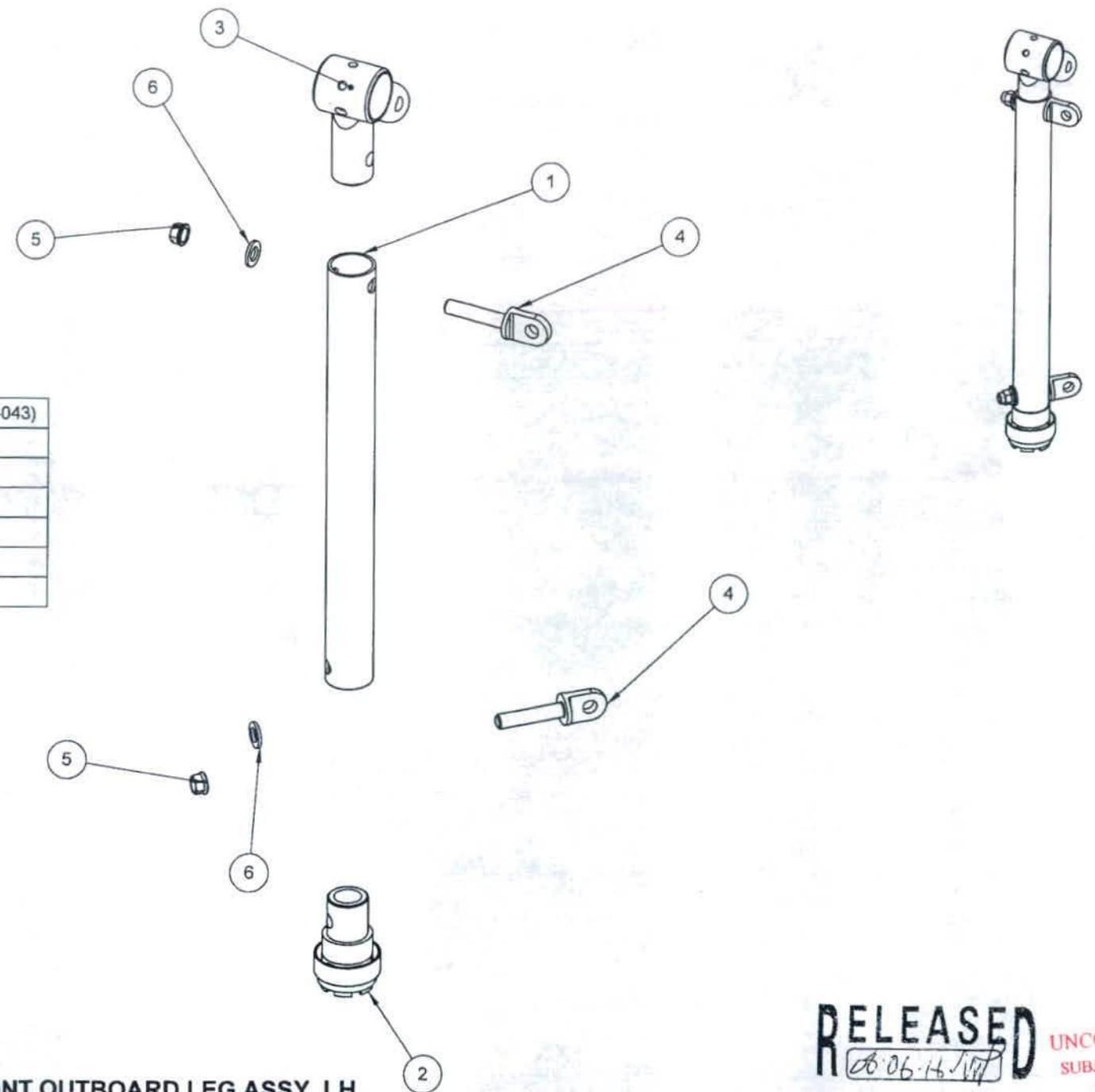
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A

A

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3768-3	FRONT OUTBOARD LEG, LH	1
2	D3787-1	FOOT	1
3	D3762-041	FRONT LEG FITTING ASSY	1
4	AN45-13A	EYE BOLT	2
5	MS21042L5	NUT	2
6	NAS1149D0568J	WASHER (AN960JD516)	2

D3782-043 FRONT OUTBOARD LEG ASSY, LH



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08.06.16/17

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WORK ORDER
NO. 40070

- NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.42 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.		REV. A	
APPROVED		D3782	
DE APPR.		SHEET 2 OF 4	
DATE	08.06.04	TITLE	
		SCALE	
		NTS	
		LEG ASSEMBLY	
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8

7

6

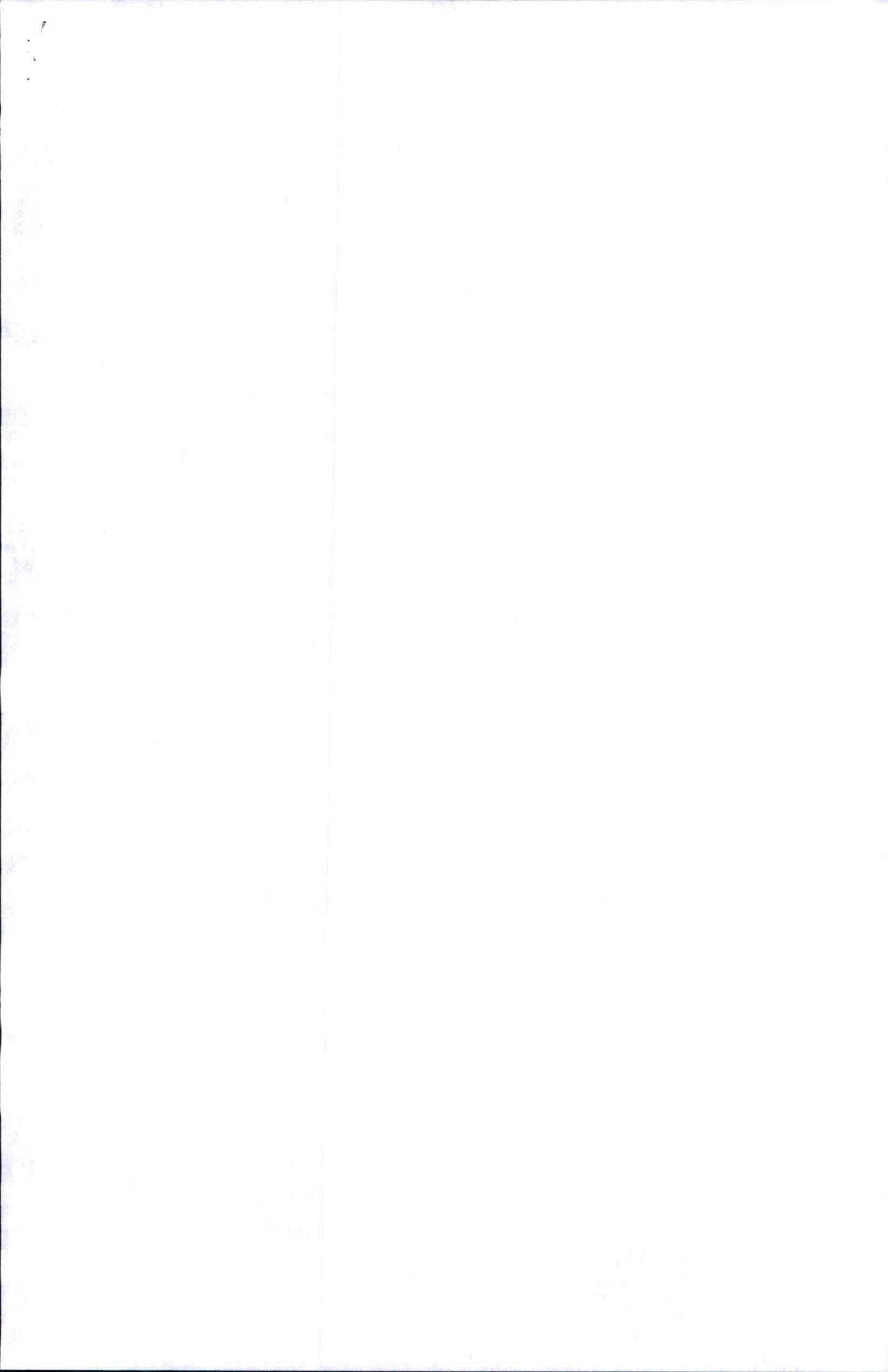
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3

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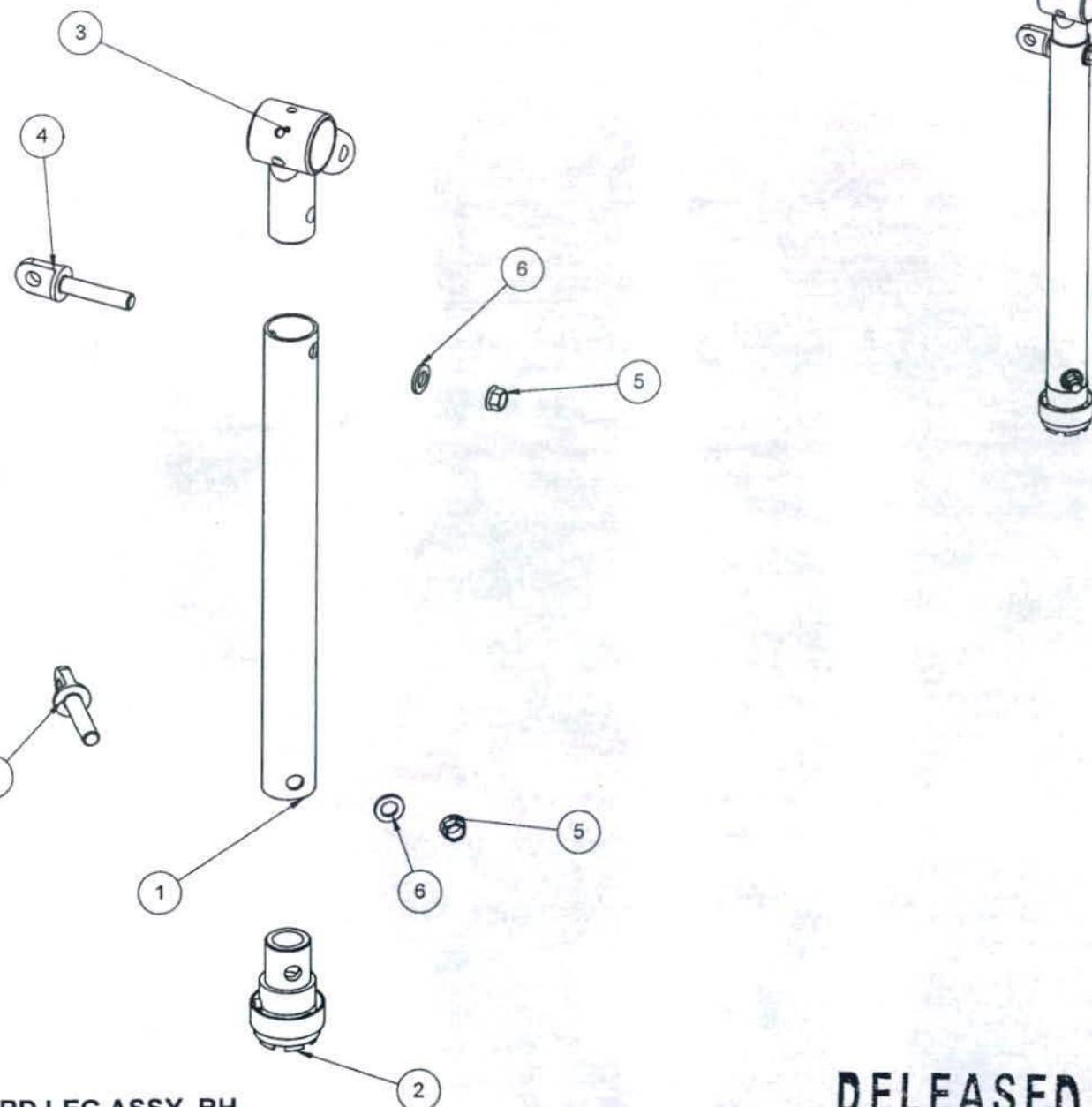
1



8 7 6 5 4 3 2 1

D

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3768-4	FRONT OUTBOARD LEG, RH	1
2	D3787-1	FOOT	1
3	D3762-041	FRONT LEG FITTING ASSY	1
4	AN45-13A	EYE BOLT	2
5	MS21042L5	NUT	2
6	NAS1149D0568J	WASHER (AN960JD516)	2



D3782-044 FRONT OUTBOARD LEG ASSY, RH

- NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.42 lbs

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APPROVED	<i>RT</i>	SHEET 3 OF 4
DE APPR.	<i>RT</i>	TITLE
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		NTS
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8 7 6 5 4 3 2 1

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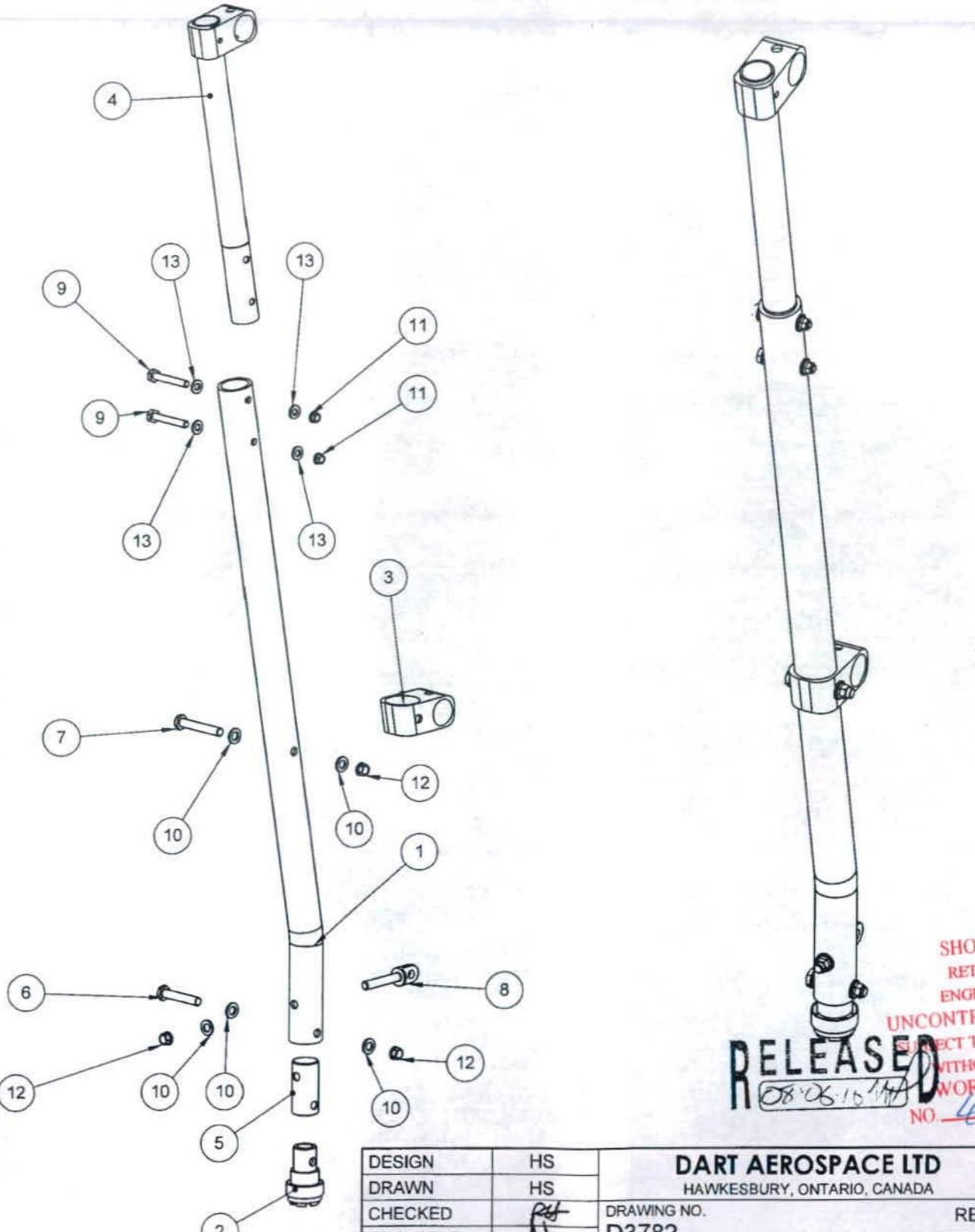
A

A

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-045)
1	D3772-1	BACK LEG	1
2	D3787-1	FOOT	1
3	D3764-1	BACK LEG FITTING	1
4	D3773-041	HEAD REST ADAPTER ASSY	1
5	D3786-1	SLEEVE	1
6	AN5-15A	BOLT	1
7	AN5-17A	BOLT	1
8	AN45-15A	EYE BOLT	1
9	AN4-15A	BOLT	2
10	NAS1149D0568J	WASHER (AN960JD516)	5
11	MS21042L4	NUT	2
12	MS21042L5	NUT	3
13	NAS1149D0463J	WASHER (AN960JD416)	4

D3782-045 BACK LEG ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 4.71 lbs



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APPROVED	<i>Re</i>	
DE APPR.	<i>Re</i>	
DATE	08.06.04	

DRAWING NO.
D3782
REV. A
SHEET 4 OF 4

TITLE
LEG ASSEMBLY
SCALE
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